

Date: Wednesday, 6/6/2007 1:53:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GASKET
Job Number	: 32788		
Estimate Number	: 12716		
P.O. Number	: N/A	Part Number	: D353635
This Issue	: 6/6/2007 S.O. No. : N/A	Drawing Number	: D3536 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 31996	Material	: N/A
Written By	:	Due Date	: 6/19/2007
Checked & Approved By	: <u>07.06.07</u>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.6507 sf(s)/Unit Total : 13.0137 sf(s)

NEOPRENE SHEET 0.063

Batch: M103104

SAD 07/06/14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: AProg Rev: A

2-Deburr if necessary

SAD 07/06/14

20

PTD

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/14

20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EN 07/06/14 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1


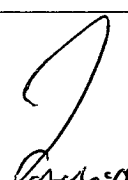
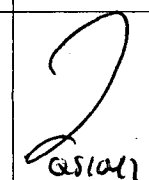
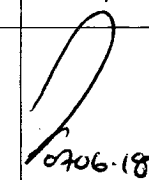
Identify and Stock

Location: _____

07/06/14 (20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/19	2.0	4 part scrap because machine was not feeding sand because of a block in the hose. Parts are <u>very</u> ugly.		Scrap, destroy, replace - Stop machine fix problem	SAD 07/06/19			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:53:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32788

Part Number: D353635

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

RD 07/06/09

Job Completion



W 07-06-09

W/O:			WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32788
Description: Gasket		Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.250	✓		M-T	
19.75	+/-0.030	19.75	✓		M-T	
17.75	+/-0.030	17.75	✓		M-T	
14.25	+/-0.030	14.25	✓		M-T	
9.50	+/-0.030	9.50	✓		M-T	
4.75	+/-0.030	4.75	✓		M-T	
2.00	+/-0.030	2.00	✓		M-T	
6.00	+/-0.030	6.00	✓		M-T	
6.75	+/-0.030	6.75	✓		M-T	
0.30	+/-0.030	0.308	✓		Vern	
0.30	+/-0.030	0.308	✓		Vern	
1.89	+/-0.030	1.88	✓		Vern	
Ø0.19	+0.005/-0.001	0.20	✓		Vern	
0.063	+/-0.010	0.059	✓		Vern	

Measured by:	SM
Date:	07/06/18

Audited by:	SM
Date:	07/06/18

Prototype Approval:	N/A
Date:	N/A

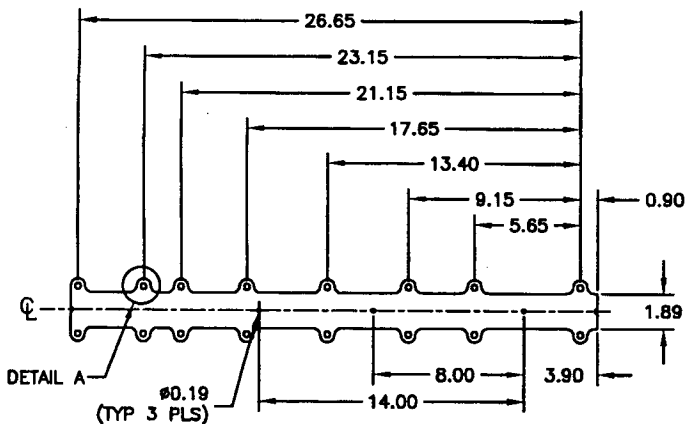
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

DART

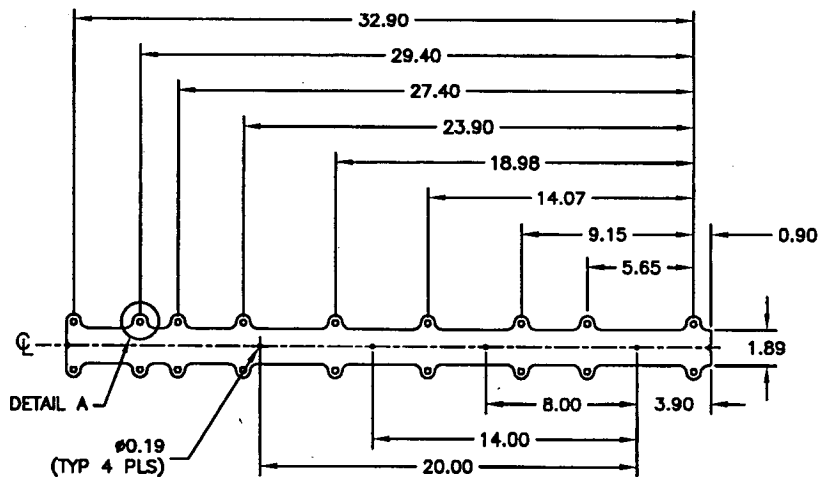
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09.02.12-11

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	AT	APPROVED		PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10



D3536-11 GASKET



D3536-13 GASKET

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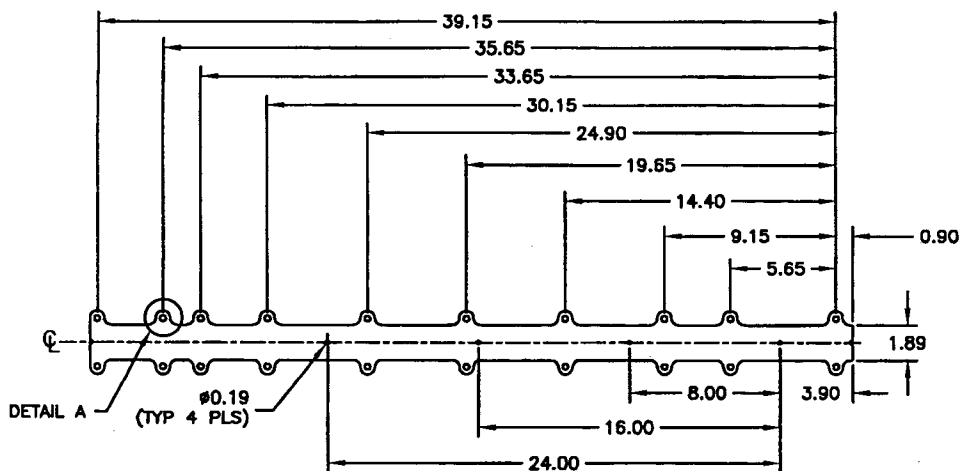
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

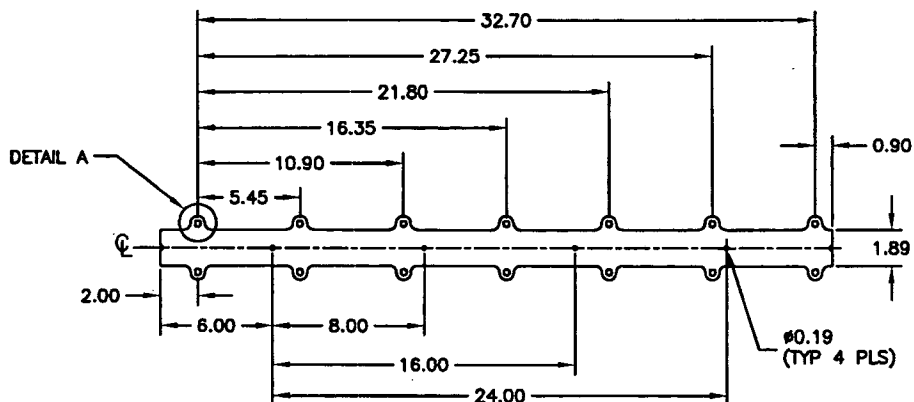


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DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 2 OF 6
		SCALE	1:10	

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D3536-15 GASKET



D3536-21 GASKET

NOTES

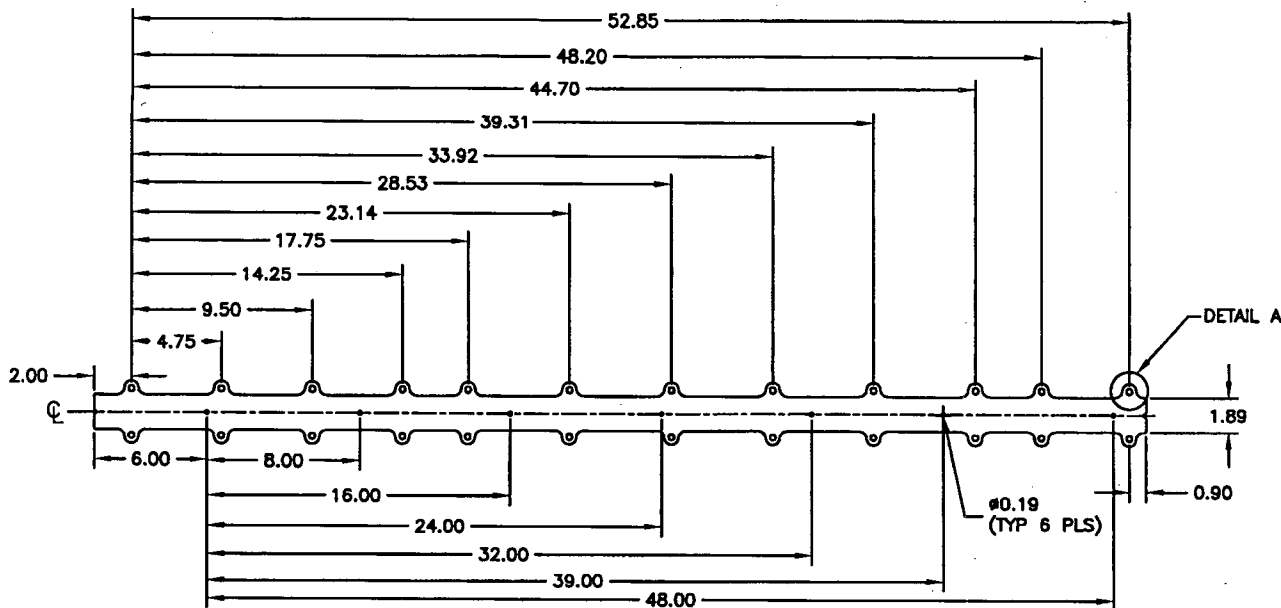
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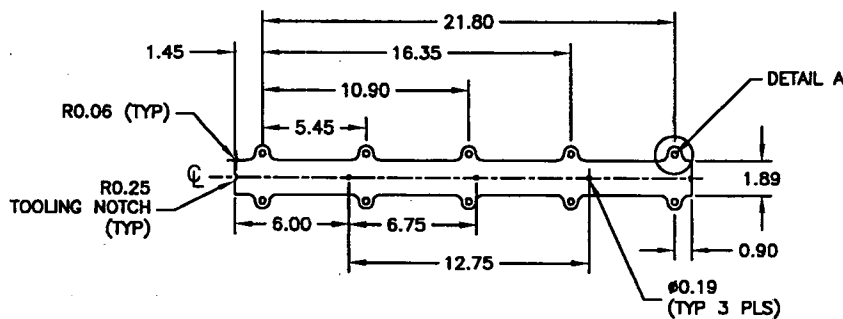
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 3 OF 6
		SCALE	1:10	

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D3536-23 GASKET



D3536-25 GASKET

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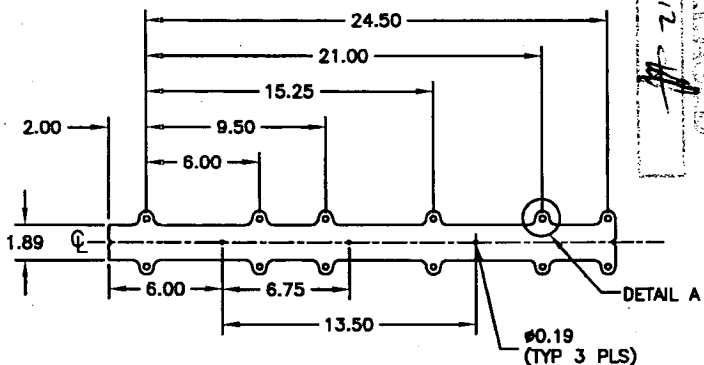
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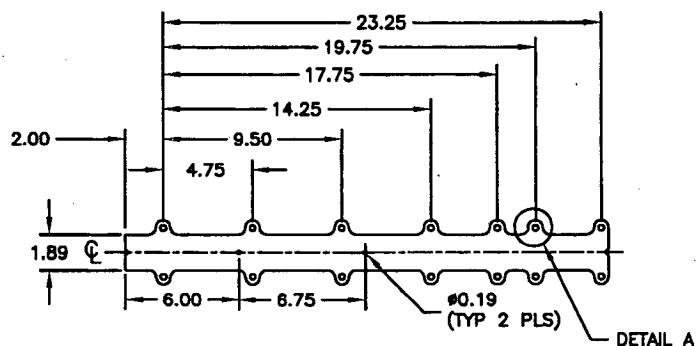
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DATE 06.10.25	TITLE GASKET	SHEET 4 OF 6	SCALE 1:10

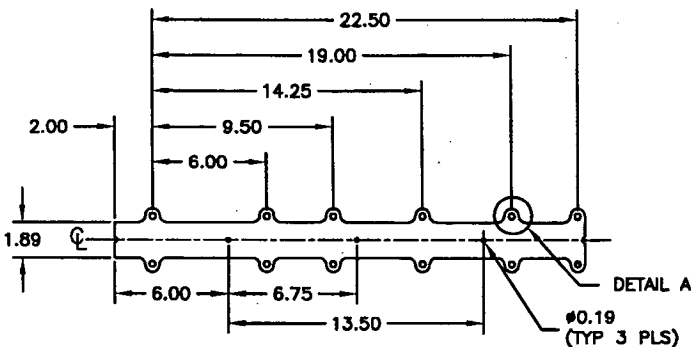
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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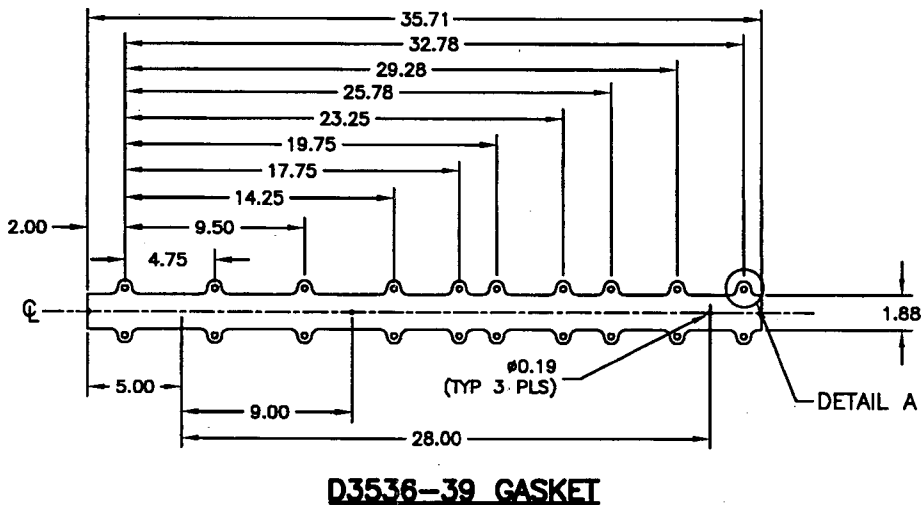
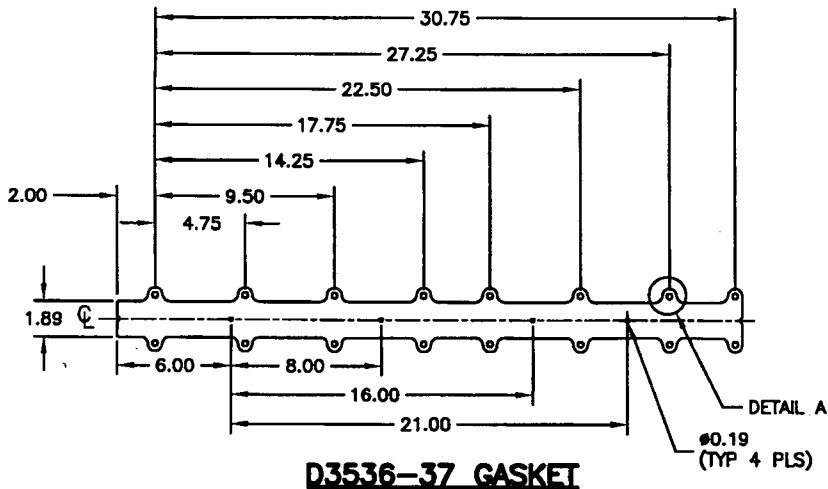
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DATE 06.10.25	TITLE GASKET	SCALE 1:10	

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NOTES

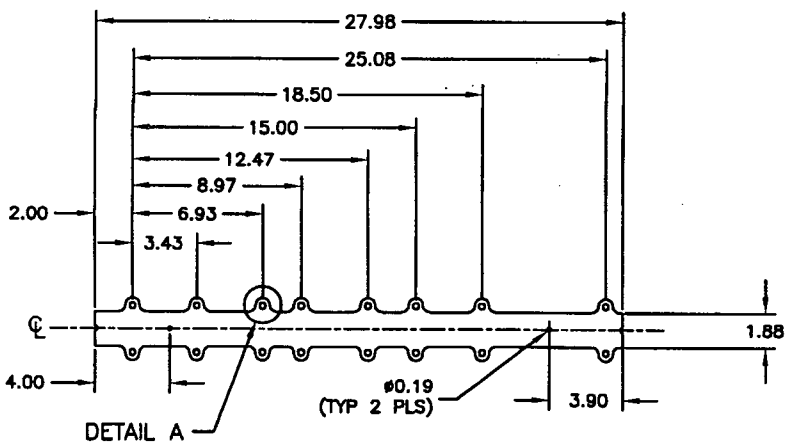
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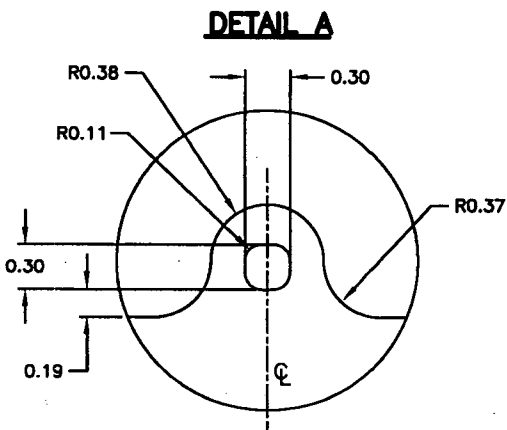


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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 6 OF 6
				SCALE 1:10

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07.02.12 CH



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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